



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2855-5

Job Sheet 162158



Part No: D2855-5

Job Qty: 100 ea

Part Name: Cap



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 11/15/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV C IPP REV:A 17.05.10 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
100	Purchasing	100 pcs	11/13/17	0.00	0.00	Purchasing	
110	Packaging	100 pcs	11/13/17	0.00	0.00	Packaging2	
120	QC	100 pcs	11/13/17	0.00	0.00	QC6	
130	Small Fab	100 pcs	11/14/17	0.00	10.99	Small Fab	
142	Mill Conv	100 pcs	11/14/17	0.00	12.50	Mill Conv 1	
143	QC	100 pcs	11/14/17	0.00	0.00	QC5	
150	Powdercoat	100 pcs	11/14/17	0.00	3.33	Powdercoat1	
160	QC	100 pcs	11/14/17	0.00	0.00	QC3	
170	Small Fab	100 pcs	11/15/17	0.00	6.67	Small Fab	
180	QC	100 pcs	11/15/17	0.00	0.00	QC5	
190	Packaging	100 pcs	11/15/17	0.00	0.00	Packaging3	
200	QC21-SA	100 Ea	11/15/17	0.00	0.00	QC21	

Part Op 110 - Receive & Inspect for Damage & Mat'l Certs

Descriptions: 120 - QC6- All purchased or subcontracted products

142 - Manufacture as per dwg

143 - QC5- Inspect part completeness to step on W/O

150 - White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum

160 - QC3- Inspect Part Finish

180 - QC5- Inspect part completeness to step on W/O

190 - Identify as per dwg & Stock Location:

200 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
100-Purchasing	D2855P	100	0	0	0
170-Small Fab	ALS7-1032-225	100	0	0	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE
S002078



Cap

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA

TEL.: 1 613 632-5200

Email: sales@dartaero.com

www.dartaerospace.com

PART NO: D2855 - 5
Revision:
Operation: Purchasing
Quantity: 114
Change No:

Mfg Date: 10/25/17

Job No: 162158

Work Order ID 162158

Monday, May 29, 2017 11:05:29 AM

162158

Page 1

Item ID: D2855-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cap
 Start Date: 5/30/2017 Start Qty: 100.00 ***100*** Cust Item ID:
 Required Date: 7/4/2017 Req'd Qty: 100.00 ***100*** Customer:

Reference: **DAS 13 9-89**
 Approvals: Process Plan: **DAS 13 9-89** Date: **MAY 29 2017** Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2855	C								
100	PURCHASING	0.00							DAS 13 9-89
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: 36487								
	Cast per Dwg D2855								
	Material Release Note Required								
	Supplier: Metallurgie SYCA								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	2.00							
Packaging	Ensure Material Release Note is attached								
120	QC6- All purchased or subcontracted products	0.00							
120									
QC	Memo	0.00							
Quality Control									

100 MAY 30 2017
110 SP 17-10-25

1 DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 162158

Monday, May 29, 2017 11:05:29 AM

162158

Page 2

Item ID: D2855-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Cap
Start Date: 5/30/2017 Start Qty: 100.00 ***100*** Cust Item ID:
Required Date: 7/4/2017 Req'd Qty: 100.00 ***100*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab	Small Fab	0.00							
	Memo	7.02							
Small Fab	1- Drill ONE SIDE ONLY as per Dwg D2855 using DT8235 2- Open hole ONE HOLE to 0.297"								
142 *142* Mill Conv	Manufacture as per dwg	0.00							
	Memo	7.86							
Conventional Milling Machine	1- MILL to length as per dwg use DT10248 JAWS 2- Deburr								
143 *143* QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	2.00							

Work Order ID 162158***162158***

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Item ID: D2855-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cap

Start Date: 5/30/2017 Start Qty: 100.00

100

Cust Item ID:

Required Date: 7/4/2017 Req'd Qty: 100.00

100

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat	Memo	1.39							
Powder Coating	START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____								
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	1.00							
Quality Control									
170		0.00							
170	Small Fab								
Small Fab	Memo	4.51							
Small Fab	Install Insert as per Dwg D2855								

162158

Page 4

N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

100

100

Reference:

Run Start *NR1*

Stop *NR2*

[illegible]

Picklist Print

Monday, May 29, 2017 11:05:28 AM

Page 1

Work Order ID: 162158

162158

Parent Item: D2855-5

D2855-5

Parent Item Name: Cap

Start Date: 5/30/2017

Required Date: 7/4/2017

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP REV:A 17.05.10 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-225	AELS8-1032-225	Purchased	No			170	Each	120.0000	1	100			
AI S7-1032-225									**				

Insert

Location

Loc Qty

Loc Code

FG

120

118520

120

D2855P

Purchased

No

100

Each

0.0000

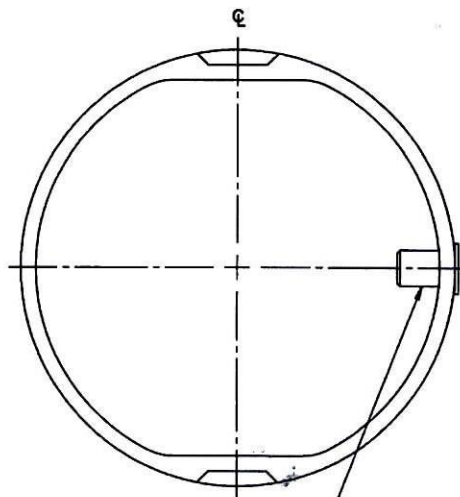
1

100

D2855P

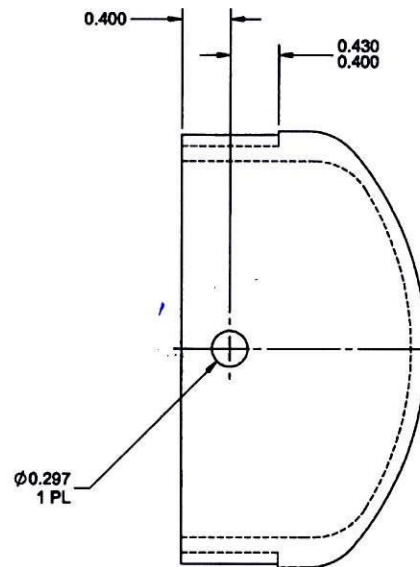
Cap

~~100~~ SP17-10-25
114X.



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
1 PL

D2855-5 CAP
(MAKE FROM D2855C CASTING)



MAY 29 2017
DAS
13
9-89
W10:162158

NOTES:

- 1) MATERIAL: MAKE FROM D2855C
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

RELEASED
2017-05-08

APPROVED

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	WK		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	JFS	D2855	SHEET 4 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CAP	NTS
DATE	17.03.01	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO36487

Supplier: MES001-VC
Metallurgie SYCA
500 Principale, 0
St.Dominique
QC
JOH 1LO Canada
Phone: 450-261-0853
Fax: 450-261-0894

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO36487
PO Date: 5/30/17
Due Date: 10/20/17
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Pymt Terms: net 30

Freight Terms:

Special Comments: ADMIN FEE INCLUDED IN PRICING OF PARTS.

Items

Line Item	Part	Rev	Description	Item Tax	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	D2855P	-	Cap DWG REV A		Firmed	10/20/17	100 pcs	0 pcs	100 pcs	\$15.00/pcs	\$1,500.00

recu 104x

Line Item Note B162158

Grand Total: \$1,500.00

Order Notes

DWG REV A

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/6/17 12:43 PM dart.lavoie.chantal

SPA-10-25

MÉTALLURGIE SYCAINC
500 RUE PRINCIPALE
ST-DOMINIQUE, QUÉBEC
J0H 1L0

N° D'ENR. DE TAXE

TAX REG. NO.

N° DE COMMANDE PO 36487

DATE 19-10-2017

ORDER NO.

VENDEU A

SOLD TO DART AIRCRAFT LTD.

ADRESSE

1270, ABERDEEN STREET

EXPÉDIE À

HAVERSBURY, ONT

SHIP TO

ADRESSE

K6A-1K7

DATE D'EXPÉDITION
SHIPPING DATE

VIA

CONDITIONS
TERMS

ACHETEUR
BUYER

VENDEUR
SALESPERSON

114

D-2855

2 BOXES X 57 POU X 30 POU

TRANSPORT FEDEX

THANKS FOR YOUR SUPPORT

574954

SIGNATURE

SPA-10-25

Blueline DCB27

FORMULAIRE DE VENTE - SALES ORDER

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MÉTALLURGIE SYCA Inc.

500, Principale
St-Dominique, Québec

J0H 1L0

Tél: (450) 261-0853

Fax: (450) 261-0894

E-mail: syca@qc.aira.com

W W W . S Y C A - I N C . C O M

CERTIFICATE OF COMPLIANCE

COMPANY: DART AEROSPACE LTD
1270, ABERDEEN STREET
HAWKSBURY, ONTARIO
K6A 1K7

DATE: 2017-10-23RD

SHIPPING MEMO: 574954

TRANSPORT: VIA FEDEX COLLECT

NUMBER OF PAGES: 2

DESCRIPTION	QUANTITY	PART CODE	P.O NUMBER
CAP D-2855	114	D-2855	36487

All items specified in this compliance certificate are manufactured in Canada.

-PRODUCTION LOT: KJJ10102017

-ALLOY: A-356

-NORME: ASTM B-85

-CHEMICAL ANALYSIS: SUPPLY

-VISUAL INSPECTION: DONE

-DIMENSIONAL INSPECTION: NON-APPLICABLE

-SURFACE SMOOTHNESS : ALUMINIUM ASSOCIATION DATA

ROUVILLE STATION INC.
1032, BOUL. RICHELIEU
RICHELIEU (QUÉBEC)
J3L-0L7

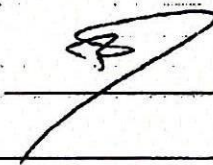
TEL : (450) 658-2183

TEL : (450) 658-2808

FAX : (450) 658-1461

Coulée # 119 SR

<u>ELEMENT:</u>	SI	FE	CU	MG	MN	NI	TI	ZN	CR	SR
<u>ALLIAGE</u>	6.5 - 7.5	.50	.10	.30 - .45	.05	*	.20	.05	*	*
<u>(356.1)</u>										
<u>A356.0</u>		.20	.20	.25 - .45	.10		.20	.10		.007
<u>ANALYSE MOYENNE:</u>	7.33	.19	.04	.40	.02	.03	.10	.006	.003	.003

CHEF DE LABORATOIRE: 

Date : 15-03-2016